

Date: Thursday, 3/30/2006 8:30:28 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE BRACKET
Job Number	: 26408		
Estimate Number	: 10347		
P.O. Number	: N/A	Part Number	: D28572
This Issue	: 3/30/2006 S.O. No. : N/A	Drawing Number	: D2857 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: 26209	Material	: N/A
Written By	: <u>See comment below</u>	Due Date	: 4/6/2006
Checked & Approved By	: <u>SA 06.03.30</u>	Qty:	40 Um: Each
Comment	: Est C 06.06.22 Removed P/O for powder coat EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B2000X01250	6061-T6 Bar 2.0" x 1.25"
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Comment: Qty.: 0.4594 f(s)/Unit Total: 18.3750 f(s)  
 Material: 2.00" X 1.25"  
 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)  
 (M6061T6B200001250)  
 Batch M100451

SA 06.03.30 40

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
 Cut blanks 5.2"

SA 06.03.30

(40)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine per folio D2857-1

SA 06.03.30 D2857-2

JL / SA 06.03.30

40

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL / SA 06.03.30

40

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/04/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 3/30/2006 8:30:28 AM  
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## Process Sheet

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Drawing Name: HINGE BRACKET

Job Number: 26408

Part Number: D28572

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

JL 06-04-01 40

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

SAD 06-04-02 40

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-04-03

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

DL 06-04-04 40

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/4/10 40

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 2T165

AR 06-04-10 40

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/11 40

Job Completion



U Downell

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	26408
<b>Description:</b> Hinge Bracket		<b>Part Number:</b>	D2857-2
<b>Inspection Dwg:</b> D2857 <b>Rev:</b> A1		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010					
0.340	+/-0.010					
1.110	+/-0.005					
1.790	+/-0.010					
1.320	+/-0.005					
2.000	+/-0.010					
Ø0.171	+0.005/-0.000					
0.147	+/-0.010					
0.376	+/-0.010					
0.126	+/-0.010					
0.611	+/-0.010					
0.063	+/-0.010					
Ø0.166	+0.005/-0.000					
0.911	+/-0.010					
0.600	+/-0.010					
0.125	+/-0.010					
0.150	+/-0.010					

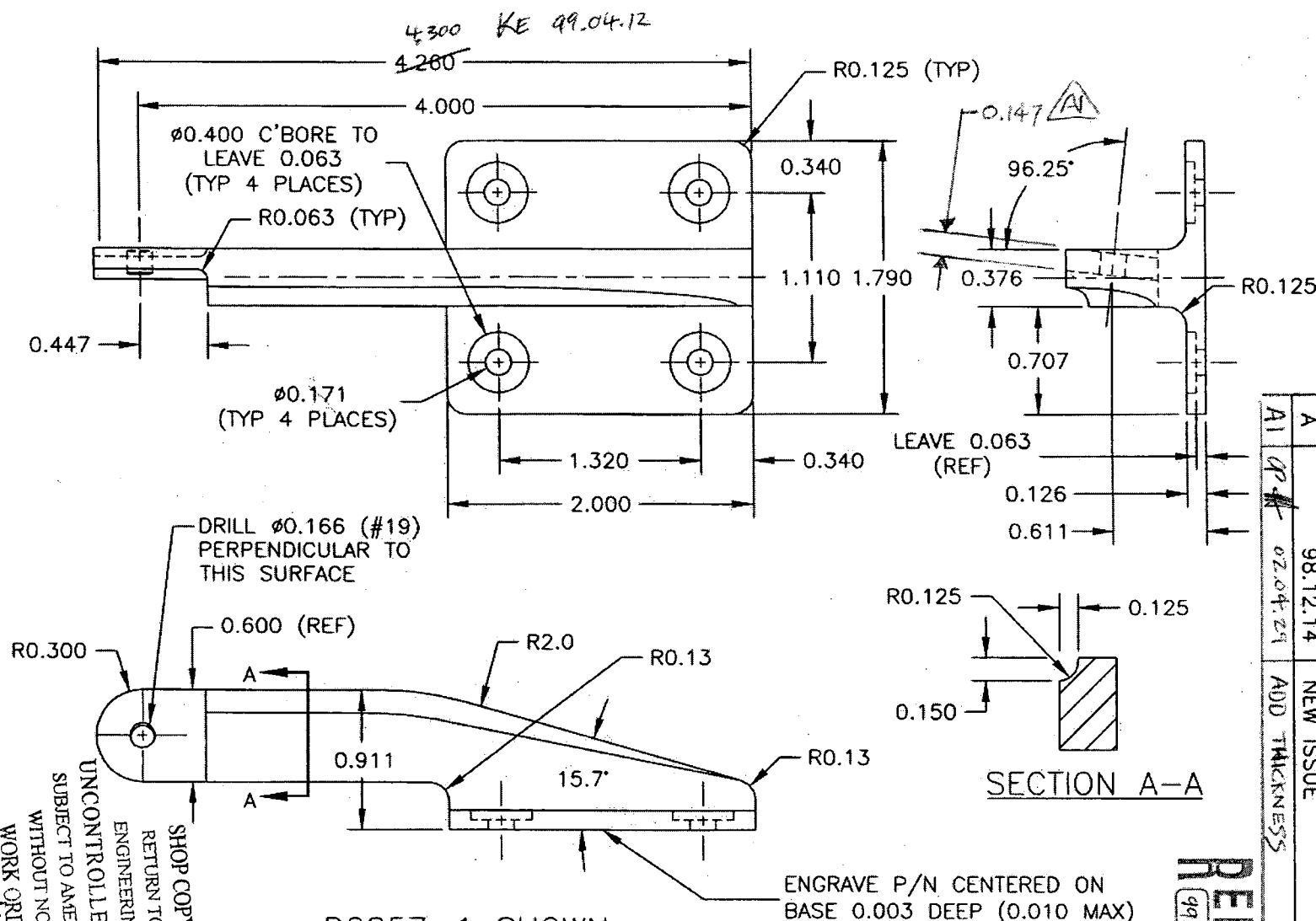
<b>Measured by:</b>	SD	<b>Audited by:</b>	gmk	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	06.03.30	<b>Date:</b>	06/04/01	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	



DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	SP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	SP	D2857
DATE	TITLE	REV. A
98.12.14	HINGE BRACKET	SHEET 1 OF 1
ADD THICKNESS	NEW ISSUE	SCALE
A	98.12.14	1:1

RELEASED  
99.01.06 KE



D2857-1 SHOWN  
D2857-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)  
FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER